

Aero Design Ltd.**Work Order Control Sheet****Work Order#:** 2016-58 **Date Opened:** 14 April 2016 **Title:** Assembly**Aircraft OEM:** MD Helicopters **Aircraft Model:** 600N **Product Type:** Cabin Step **Product Model:** Standard **Quantity:** 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
N/A
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

N/A
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
82910	0	Step Assembly	JC

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Initial or N/A

Work performed by:

Print: D. BartfaiSign: D. BartfaiSCA: AD07Date: 15-Apr-16

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: J. ClarkeSCA: AD02Date: 15-Apr-16

Work Order closed by:

Print: J. ClarkeSign: J. ClarkeSCA: AD02Date: 15-Apr-16

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

Job #: 829
Project: Cabin Step
Type: MD600N

Approval: SH09-1
Drawing List: DCL829-11, Rev. 1

Fabrication and Assembly Drawing(s)	Description
82910, Rev. 0	Step Assembly

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	Y ✓
Document Control List revision level matches (or exceeds) STC:	Y ✓
Drawings revision levels match Document Control List:	Y ✓
Purchase order or Work order source is recorded for each part/ass'y:	Y ✓
Tests and inspections specifically called out on drawings are complete:	Y N/A
Release tags associated with all fabricated parts are attached:	Y ✓
All mounting hardware and supplies are included:	Y N/A

List all non-conformities raised: _____

Welder Signature: David Murray Date: April 15/2016

Inspector Signature: JH CCL Date: 15 APR 2016

Drawing: 82910, Revision 0
 Assembly: 82910-01 Step Assembly
 Batch Quantity: 1 Step

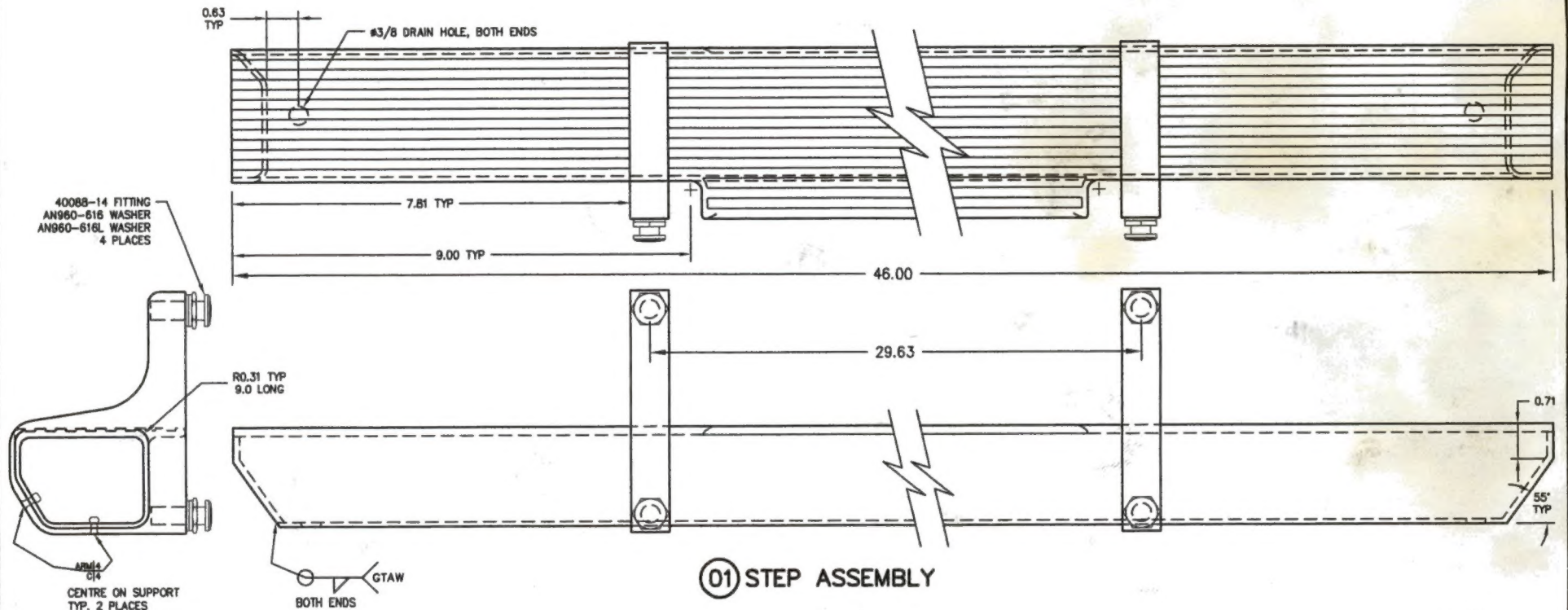
Qty	Part #	Description	Material	P.O./W.O.	Checked
1	82910-01	Step Assembly			
1	78230	Step Extrusion	6061-T6 Aluminum	8021	
2	80021-01	Step Support	6061-T6 Aluminum, 3.5 x 1 bar	8089 / WD 2009-13	
2	82910-04	Cap	6061-T6 Aluminum, 0.125 sheet	14043	
4	CR3212-4-04	CherryMax Rivet		13006	
4	40088-14	Fitting	Ancra	12089	
4	NAS1149F0663P	Washer		15074	
4	NAS1149F0632P	Washer		11077	
4	3591-6CN563	Heli coils		12080	

Processes	Per	Mat'ls Used	Initials
Welding	AMS2685C	ER4043 Rod	DRM
Powder Coating	N/A JC.	PO# 14056	

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



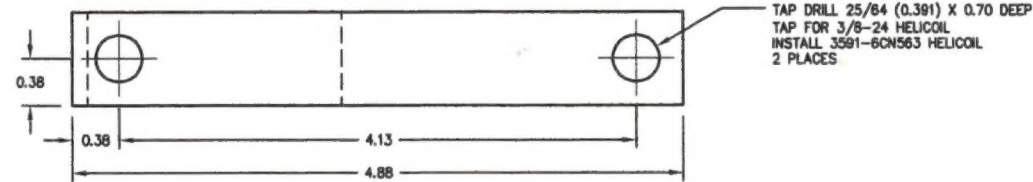
NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 6061 ALUMINUM TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ANSI/AWS ER4043.
3. ALL ALUMINUM PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED AFTER ASSEMBLY. TREAD AREA IS TO BE PAINTED WITH RANDOLPH X1567 WINGWALK GRIP PAINT OR EQUIVALENT AFTER POWDER COATING.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
4	AN960-616L		WASHER			
4	AN960-616		WASHER			
4	40088-14		FITTING	ANCRA		
4	CR3212-4-4		BLIND RIVET			
2	82910-04	04	CAP	6061-T6 ALUMINUM	QQ-A-250/11	0.125 SHEET
1	80021-01	03	STEP SUPPORT			
A/R	78230	02	STEP EXTRUSION			
	82910-01	01	STEP ASSEMBLY			

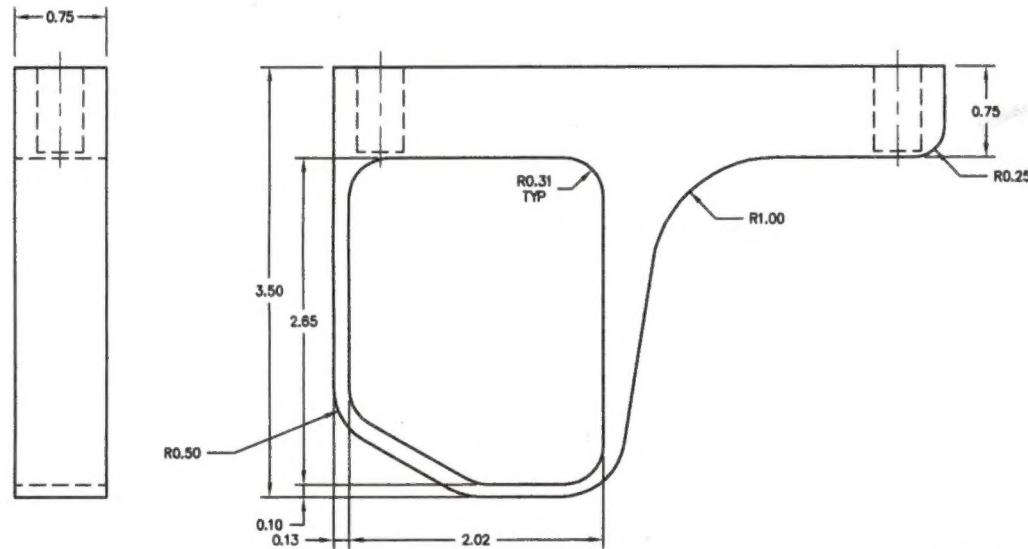
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		MCDONNELL DOUGLAS MD600N QUICK RELEASE STEP STEP ASSEMBLY					
SCALE 1 : 2		DWG. SIZE		DWG. NO.		REV.	
SHEET 1 OF 1		A3		82910		0	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. PART IS TO BE CNC MACHINED USING DRAWING AS A TEMPLATE.



2	3591-6CN563		SELF LOCKING HELICOIL			
	80020-01	01	STEP SUPPORT	6061-T6 ALUMINUM	QQ-A-200/8	3.5 X 1 BAR
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

LIST OF MATERIALS

① STEP SUPPORT

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		QUICK RELEASE STEP INSTALLATION STEP SUPPORT FABRICATION			
	SCALE 1 : 1 SHEET 1 OF 1	DWG. SIZE A3	DWG. NO. 80021	REV. 0		

**Aero Design Ltd**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

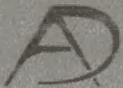
AMF 73-04

Nomenclature: Strut (Aft) No. of pieces: 1Manufacturer: Aero Design Ltd.Part No.: 82831-02 Serial No.: NSNTTSN: NP TSO: N/A Rem.: N/AWork Order No.: 2016-58Remaining Tasks to be Performed: Install and RigSignature: [Signature]Date: 25 May 16 Lic. No. / SCA AD01

Form# 20.E.02

Rev. 1 24 April 2014

Serviceable

**Aero Design Ltd.**

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Strut (Fwd) No. of pieces: 1Manufacturer: Aero Design Ltd.Part No.: 82831-01 Serial No.: NSNTTSN: NP TSO: N/A Rem.: N/AWork Order No.: 2016-58Remaining Tasks to be Performed: Install and RigSignature: [Signature]Date: 25 May 16 Lic. No. / SCA AD-01

Form# 20.E.02

Rev. 1 24 April 2014

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Remarks



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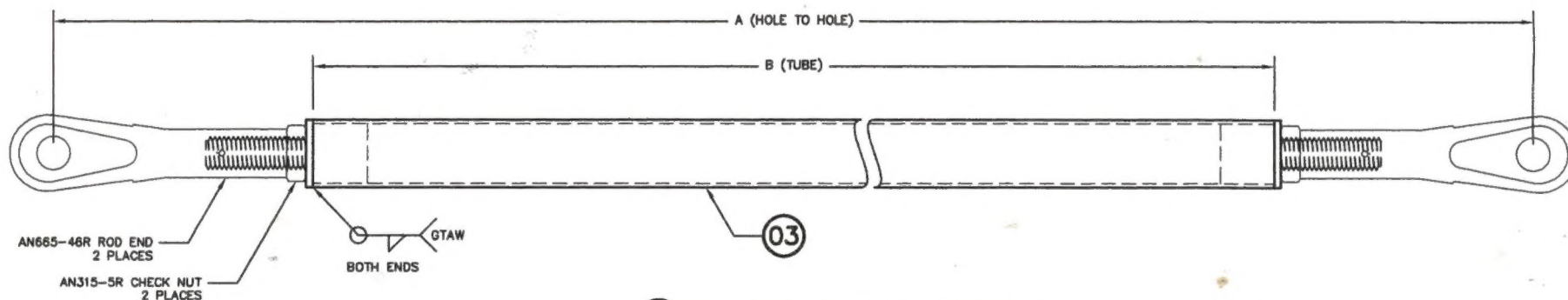
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AMF 73-04

Serviceable

Remarks

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



01 FORWARD STRUT ASSEMBLY

A = 39.3 (REF); B = 34.5

A = 990 mm = 39.0 in

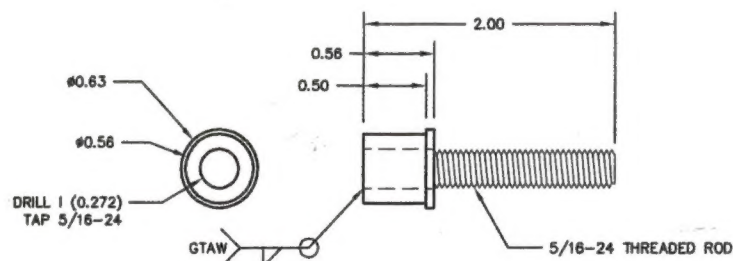
02 AFT STRUT ASSEMBLY

A = 22.5 (REF); B = 18.00

A = 620 mm = 24.4 in

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
3. THOROUGHLY DEGREASE AND POWDER COAT ALL STEEL PARTS PRIOR TO ASSEMBLY.



04 THREADED INSERT

2	2	AN315-SR	07	CHECK NUT				
2	2	AN665-46R	06	THREADED ROD END				
2	2	82831-05	05	5/16-24 THREADED ROD	ALLOY STEEL	GRADE 8		
2	2	82831-04	04	THREADED INSERT	4130 STEEL COND. N	MIL-S-6758	0.625 ROD	
1	1	82831-03	03	TUBE	4130 STEEL COND. N	MIL-T-6736	0.625 X 0.035 TUBE	
		82831-02	02	AFT STRUT ASSEMBLY				
		82831-01	01	FORWARD STRUT ASSEMBLY				
02	01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY								

LIST OF MATERIALS

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APPROVALS	DATE
DRAWN: JEFF CLARKE	10 NOV 2008
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1

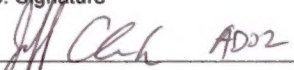
AERO DESIGN LTD.

CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M
2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7
Tel: (408) 850-9087 fax: (408) 850-8833 www.aerodesign.ca

MCDONNELL DOUGLAS MD600N QUICK RELEASE CARGO BASKET STRUT ASSEMBLIES

SCALE	DWG. SIZE	DWG. NO.	REV.
1 : 1	A3	82831	0

SHEET 1 OF 1

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2016-0016	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2016-58	
6. Item 1.	7. Description Step Assembly	8. Part Number 82910-01	9. Qty. 1	10. Serial/Batch No. N/A	11. Status/Work New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<div style="border: 1px solid black; padding: 5px;"> 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. </div>			
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 14 April 2016		14d. Name		14e. Date (dd/mmm/yyyy)
Installer Responsibilities						
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						

JMS